

# Work Order ID 68498

Thursday, April 14, 2011 10:15:49 AM



Page 1

Item ID: D412-630-032

Accept



Setup Start



Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 4/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/04/14 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: 4 SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-630	Rev M								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG003

11 04 26 1  
for CL 11-4-26

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.17

\*\*\*\*ensure tension to retract step is 11 to 18 lbs before installing lockwire.\*\*\*\*

A/R MS20995C41 batch: M101537

Ep. 11/04/26 1

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

\*\*\*\*ensure tension to retract step is 11 to 18 lbs \*\*\*\*

Test fit on aircraft in Eng. lab.

8 Wlb/26

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68498**

Page 2

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Item ID: D412-630-032

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Revision ID:

Stop



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Start Date: 4/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/4/26 22

140

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

11/4/26 04 26 ①

150

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-630-032

Location:

PPP Rev:

11/4/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Thursday, April 14, 2011 10:15:49 AM

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Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 4/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/27 JG  
MF  
11-04-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries




Thursday, April 14, 2011 10:15:44 AM

[illegible]

**Required Date: 4/27/2011**

**Required Qty: 1.00**

Comments:	IPP REV. A	05.11.21	NEW ISSUE	EC	
	IPP REV. B	05.12.19	updated pick list	EC	
	IPP REV.C	07.11.12	ecn 1019, nochg	EC	verifiedby:DD IPP Rev:D
	10.05.28	added route seq	DD	verf:EC	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4  NUT		Purchased	No			130	Each	22.0000	1	12 SP 117442			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST324		22				2			
					116786	22							
AN310-5  NUT		Purchased	No			130	Each	32.0000	2	2 SP			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST324		32							
					114830	32							
AN3C5A  Bolt		Purchased	No			130	Each	1,077.000	3	3 11426 SP			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP-A		7							
					115835	7							
				ST350		1070							
					115422	52				3			
					116419	418							
					116549	100							
					117343	500							

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, April 14, 2011 10:15:44 AM

Page 2

Work Order ID: 68498

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 1.00

Required Qty: 1.00

AN44-C12 eyebolt X1	Purchased	No	130	Each	9.0000	1	1
AN4C15 BOLT X1	Purchased	No	130	Each	8.0000	1	1
AN5C11 BOLT X1	Purchased	No	130	Each	39.0000	1	1
AN5C15 BOLT X1	Purchased	No	130	Each	13.0000	1	1
AN960C10 WASHER X1	Purchased	No	130	Each	0.0000	7	7

Location Loc Qty Loc Code

ST362 9  
114669 9

Location Loc Qty Loc Code

ST358 8  
114669 8

Location Loc Qty Loc Code

ST337 39  
113950 9  
114801 30

Location Loc Qty Loc Code

ST338 13  
114669 13

Handwritten signatures and notes are present on the right side of the page, including a large signature over the first three items and another signature over the last item, along with the handwritten number 114742 and date 11/4/2011.

Thursday, April 14, 2011 10:15:44 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

Thursday, April 14, 2011 10:15:45 AM

Page 3

Work Order ID: 68498

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C516

Purchased No

130 Each

55.0000

1

1

WASHER

Location

Loc Qty

Loc Code

ST347

55

102842

55

Manufactured No

130 Each

26.0000

1

1

D3454-1

Bushing

Location

Loc Qty

Loc Code

ST054

26

58555

26

Manufactured No

130 Each

0.0000

2

2

D3454-3

Bushing

D3454-5

Manufactured No

130 Each

3.0000

2

2

Bushing

Location

Loc Qty

Loc Code

ST054

3

58556

3

Manufactured No

130 Each

13.0000

4

4

D3455-1

Spacer

Location

Loc Qty

Loc Code

ST054

13

59469

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, April 14, 2011 10:15:45 AM

Page 4

Work Order ID: 68498

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 1.00

Required Qty: 1.00

D3455-3

Manufactured No

130 Each

8.0000

2

2

Spacer

Location

Loc Qty

Loc Code

ST054

8

58559

8

130 Each

1.0000

1

1

D3462-042

Manufactured No

Bracket Assembly

Location

Loc Qty

Loc Code

ST198A

1

59471

1

130 Each

998.0000

3

3

MS21043-3

Purchased No

Nut

Location

Loc Qty

Loc Code

FG

80

103691

80

FP-B

-5

112314

-5

ST301

923

112314

923

130 Each

46.0000

2

2

MS24665-227

Purchased No

COTTER PIN

Location

Loc Qty

Loc Code

ST309

46

113845

46

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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# Picklist Print

Thursday, April 14, 2011 10:15:45 AM

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Work Order ID: 68498

Parent Item: D412-630-032

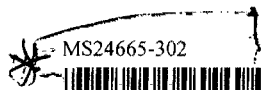
Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 1.00

Required Qty: 1.00



MS24665-302

Purchased No

~~130~~  
110 Each

22.0000

1 1

Cotter Pin

Location

Loc Qty

Loc Code

ST309

22

113644

22

130

Each

171.0000

1 1

NAS1515H5

Purchased No

Washer

Location

Loc Qty

Loc Code

FG

40

103286

20

103691

20

ST277

131

109430

131

110

Each

13.0000

2 2

D3455-1

Manufactured No

Spacer

Location

Loc Qty

Loc Code

ST054

13

59469

13

110

Each

3.0000

1 1

D3443-041

Manufactured No

Strut Weldment Assembly

Location

Loc Qty

Loc Code

ST198A

3

56061

3

Thursday, April 14, 2011 10:15:45 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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# Picklist Print

Thursday, April 14, 2011 10:15:45 AM

Page 6

Work Order ID: 68498

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 1.00

Required Qty: 1.00

D3463-042

Manufactured No

110 Each

1.0000

1

1



Step Weldment Assembly

Location

Loc Qty

Loc Code

ST494

1

62561

1

110 Each

2.0000

2

2

D3443-9

Manufactured No



Pin

Location

Loc Qty

Loc Code

ST053

2

58552

2

110 Each

20.0000

1

1

AN4C14

Purchased No



BOLT

Location

Loc Qty

Loc Code

ST358

20

114669

130

20

110 Each

135.0000

2

2

MS24665-229

Purchased No



COTTER PIN

Location

Loc Qty

Loc Code

ST309

135

111041

135

110 Each

46.0000

1

1

MS24665-227

Purchased No



COTTER PIN

Location

Loc Qty

Loc Code

ST309

46

113845

46

Thursday, April 14, 2011 10:15:46 AM

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

Thursday, April 14, 2011 10:15:46 AM

Page 7

Work Order ID: 68498

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 1.00

Required Qty: 1.00

AN4CH3



SS Bolt

Purchased No

110 Each

13.0000

2

2



*EJS 4/04/25*

Location

Loc Qty

Loc Code

ST355

13

114801

13

2

D3465-1



Washer

Manufactured No

110 Each

24.0000

1

1



*EJS 4/04/25*

Location

Loc Qty

Loc Code

ST054

24

46134

24

1

AN310-4



NUT

Purchased No

110 Each

22.0000

2

2



*EJS 4/04/25*  
M117442 (1x)

Location

Loc Qty

Loc Code

ST324

22

116786

22

1

D3443-043



Strut Weldment Assembly

Manufactured No

110 Each

1.0000

1

1



*EJS 4/04/25*

Location

Loc Qty

Loc Code

ST198A

1

56062

1

1

D3454-7



Bushing

Manufactured No

110 Each

14.0000

2

2



*EJS 4/04/25*

Location

Loc Qty

Loc Code

ST054

14

59256

14

2

Thursday, April 14, 2011 10:15:46 AM

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, April 14, 2011 10:15:46 AM

Page 8

Work Order ID: 68498



Parent Item: D412-630-032



Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 1.00

Required Qty: 1.00

AN310-7

Purchased

No

110

Each

47.0000

1

1



NUT



*EF 5/11/04/25*  
1

Location

Loc Qty

Loc Code

ST324

47

114784

47

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

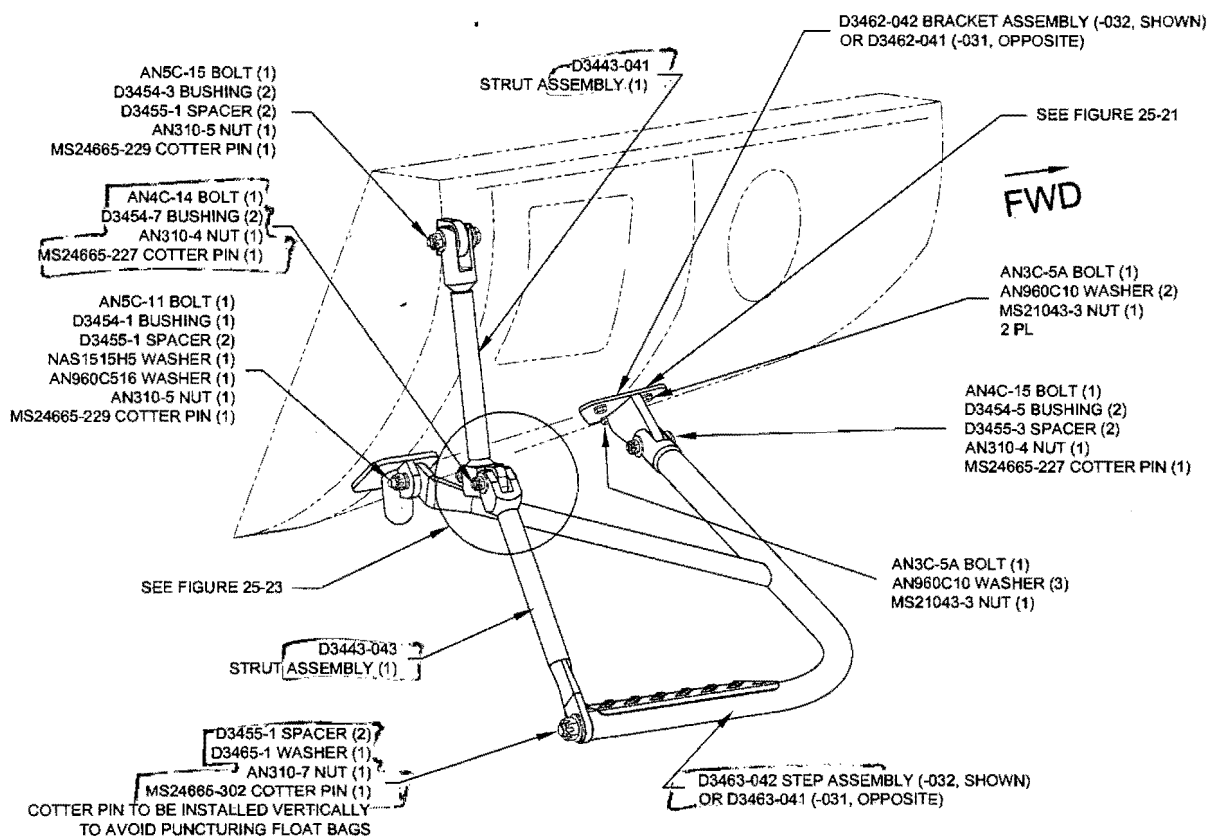


FIGURE 25-22: Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)  
D412-630-031 LH (Opposite)

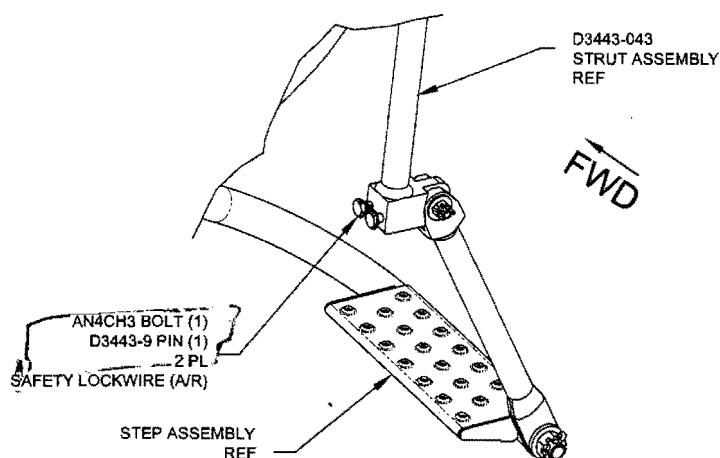


FIGURE 25-23: Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)  
D412-630-031 LH (Opposite)

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25-00-00





86489; 010

## 25.6 PARTS LIST

Qty -011	Qty -012	Qty -041	Qty -042	Part Number	Description
X				D412-630-011	HELI-ACCESS-STEP™ LH (HEAVY DUTY FOLDING)
	X			D412-630-012	HELI-ACCESS-STEP™ RH (HEAVY DUTY FOLDING)
1		X		D412-630-041	STEP ASSEMBLY LH
	1		X	D412-630-042	STEP ASSEMBLY RH
1	1	1	1	D2012-107	CLEVIS
2	2	2	2	D2022-101	SPACER
		4	4	D2652	BUSHING
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
4	4			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
		1	1	D2810-3	STRUT
		1		D2812-043	STEP ASSEMBLY LH (REPLACES D2812-041)
			1	D2812-044	STEP ASSEMBLY RH (REPLACES D2812-042)
		3	3	D2813	WASHER
		1		D2990-041	STA 129 BRACKET ASSEMBLY LH
			1	D2990-042	STA 129 BRACKET ASSEMBLY RH
		2	2	AN3-20A	BOLT
1	1	1	1	AN4-10A	BOLT
4	4			AN4-15A	BOLT
2	2			AN5-15A	BOLT
		3	3	AN8-16	BOLT
		3	3	AN310-8	NUT
		3	3	MS24665-285	COTTER PIN (OR AN380-3-4)
		4	4	AN960JD10	WASHER
8	8	1	1	AN960JD416	WASHER
4	4			AN960JD516	WASHER
		6	6	AN960JD816	WASHER
		4	4	MS21042L3	NUT (OR MS21042-3)
5	5	1	1	MS21042L4	NUT (OR MS21042-4)
2	2			MS21042L5	NUT (OR MS21042-5)

